Work Ord Wednesday, Sep											Page 1
Item ID: Revision ID:	D3873-1			Accept				S	Setup Sta	rt	
Item Name:	Bushing								Sto	р	
Start Date: Required Date Reference:	9/22/2010 : 9/29/2010	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00		10 110 110 10 110 110	Cust Item I Customer:	D:					
Approvals:	Process Pla	nn:	Date: //	Tooling:  SPC (Y/N):	7 7 7 7	nte:		F	Run Sta Sto	<b>       </b>	
Sequence ID/ Work Center I	D	Operation Description	<u> </u>	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr				,	1.				
D3873	В										
100 Hardinge		Mana		0.00				40			
Hardinge CNC Lat	he Small	FOLIO REV DWG REV:		5 & DWG D3873 ,	10-12-						
110 		QC2- Inspect parts off ma	achine FAI/FAIB	0.00			·	70	J.		

5/ 10/02/28

Memo

Quality Control

W/O:		WORK ORDER CI	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						***************************************	
Part No	:	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _	

Part No	Part No: PAR Resolution:		Fault Categ	jory: N	NCR: Yes No DQA:			
			Disposition	ı: G	QA: N/C Closed:			
NCR:			WORK ORDE	R NON-CONFORMANC	CE (NCR)			
		Description of NC		Corrective Action Section B	<del> </del>	Verification	Annuaral	Annaval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
	1							

DATE	STEP	Section A	<b>Initial</b> Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							,	
							• • • • • • • • • • • • • • • • • • • •	
						,		
								• •

Page 2

Wednesday, September 22, 2010 10:22:22 A

Item ID:

D3873-1

Accept



Setup Start



Revision ID:

**Start Date:** 

Bushing **Item Name:** 

**Required Date: 9/29/2010** 

9/22/2010

**Start Qty: 40.00** 

Req'd Qty: 40.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



OC:

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool ID

Tool # Plan

Code

Accept Reject Qty **Qty** 

Reject

Insp. Number Stamp

**Work Center ID** 120

Sequence ID/

Quality Control

Operation **Description** 

QC8- Inspect parts - second check

Memo

0.00

B. A 10/09/27

40

130

Packaging Packaging

Identify as per dwg & Stock Location: 091

0.00

0.00

Memo

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/27 <

W/O:			WO	RK ORDER CHANG	ES					٠,
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	jory:	NCR:	es N	lo <b>DQ</b> /	<b>\</b> :	Date: _	
	R	esolution:	Disposition	ı:	_ QA: N/	C Clo	sed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (N	ICR)		**		
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	3167	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
										1

### **Picklist Print**

Wednesday, September 22, 2010 10:22:26 AM

Work Order ID: 62197

Parent Item:

D3873-1

Parent Item Name: Bushing



**Start Date:** 9/22/2010

Required Date: 9/29/2010

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

#### Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750	1814 1988: S141 851 1881	Purchased	No			100	f	62.4849	0.06	2.4			

303 Round Bar 0.750

Location	Loc Oty	Loc Code
MAT	4.2197	
107077	0	
115010	4.2197	
MAT028	40.7052	
113134	40.45	
113424	0.2552	
MAT029	17.56	
114356	17.56	

2.5 Rt S/10/04/25

ž. 6

W/O:			W	ORK ORDER CHANGE	S			
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC inspector
							1 rou mg.	
			··· <del>-</del> · · · · · · · · · · · · · · · · · · ·					
Part No	:	PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	_ Dispositi	on:	QA: N/C Cl	osed:	Date: _	····
NCR:		W	ORK ORE	DER NON-CONFORMAI	NCE (NCR	)		
DATE	STEP	Description of NC		Corrective Action Section		Verificatio		Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		, +						
						·		
		5.						

DART AEROSPACE LTD	Work Order:	02197
Description: Bushing	Part Number:	D3873-1
Inspection Dwg: D3873 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.305	+0.000/-0.002				Mre	24-5
Ø0.191	+0.005/-0.001	\$,153			Dein	11-9
Ø0.63	+/-0.030	0.624	/			```
0.060	+/-0.005	:060	/			)
0.600	+/-0.010	598				
R0.010	+/-0.010	R.015				:. ' ;;
0.030 x 20°	+/-0.010 x 0.5°	.030x20°				
-						
						,
						,
						** **
						:
L	1		_ <del></del>			

Measured by:	2/	Audited by:	B.A	Prototype Approval:	N/A
Date: /	0108/25	Date:	10/09/27	Date:	N/A

Rev	Date	Change	Revised by		Appr	oved
Α	09.05.20	New Issue	KJ 🤄	*	-100	
				7 7 -		<u> </u>

W/O:			WC	RK ORDER CHANG	ES	<del> </del>			
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>									
		PAR #:	Fault Cate	_ NCR: Yes	No <b>DQ</b>	A:	Date:		
		solution:	Disposition	n:	_ QA: N/C CI	QA: N/C Closed:			Date:
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Se		on B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector

2 D Ø0.63 R0.010 SHOPECTY RETURN TO Ø0.305<sup>+0.000</sup> С ENCLUENCE II UNCONTRACTOR SUBJECT TO A CAMPAGE AND Ø0.191 THRU 0.030 X 20° WITER 0.060±0.005 NO 62197-Bf10-9-22 CHAMFER — 0.600 **— D3873-1 BUSHING** PU ECN 61.538 A NEW ISSUE МВ 09.01.07 REV. DESCRIPTION BY DATE NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION. NOME DESIGN DART AEROSPACE USA, INC. DRAWN PORT HADLOCK, WA DRAWING NO. CHECKED REV. A D3873 MFG. APPR. SHEET 1 OF 1 TITLE APPROVED SCALE BUSHING 6) IDENTIFICATION: NONE 7) WEIGHT: 0.01 lbs DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
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NOT TO BE USED FOR ANY PURPOSE OR COMPLICATION TO ANY OTHER PRIVACE. DATE 09.01.07

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С

Dart Aerospace I
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W/O:			W	ORK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
-								Prod Wigi		
;										
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes No DQA: Date:					
	R	esolution:	on:	_ QA: N/C (	Closed:	Date: _	_ Date:			
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC Section A			on B	Verifi	cation	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	tion C	Chief Eng	QC Inspector	
<b></b>										